

Date: Thursday, 6/21/2007 2:28:54 PM
 User: Kim Johnston

Process Sheet

| | | | |
|-----------------------|---------------------------------------|------------------|---------------|
| Customer | : CU-DAR001 Dart Helicopters Services | Drawing Name | : STRUT |
| Job Number | : 33050 | | |
| Estimate Number | : 10282 | | |
| P.O. Number | : N/A | Part Number | : D2565107 |
| This Issue | : 6/21/2007 S.O. No.: N/A | Drawing Number | : D2565 REV E |
| Prsht Rev. | : NC | Project Number | : N/A |
| First Issue | : N/A | Drawing Revision | : E |
| Previous Run | : 32462 | Material | : N/A |
| Written By | : | Due Date | : 7/5/2007 |
| Checked & Approved By | : | Qty: | 10 |
| Comment | : Est:F 02-04.16 Added dwg Rev.C1 NG | Um: | Each |

Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description : | |
|---------|-----------------------|---|--------------------------------------|
| 1.0 | M304TR0750W049 | 304 RD Tube .750 x .049W | |
| | | | |
| | | Comment: Qty.: 1.1751 f(s)/Unit Total : 11.7506 f(s) Material: 304/316 SS tubing 0.750" Dia. x 0.049" wall (M304TR0750W049) | Batch No: <u>1104627</u> FF 07-07-09 |
| 2.0 | BRAKE NC | NC BRAKE | |
| | | | |
| | | Comment: BRAKE NC Punch as per Dwg D2565 using DT 8313 | FF 07-07-09 |
| 3.0 | SMALL FAB 1 | SMALL & MEDIUM FAB RESOURCE 1 | |
| | | | |
| | | Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr | SAD 07/07/09 |
| 4.0 | QC5 | INSPECT WORK TO CURRENT STEP | |
| | | | |
| | | Comment: INSPECT WORK TO CURRENT STEP | Sp 07/07/10 X10 |
| 5.0 | POWDER COATING | POWDER COATING | |
| | | | |
| | | Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3 | <u>m 101575</u> BK 07-07-10 |
| 6.0 | QC3 | INSPECT POWDER COAT/CHEMICAL CONVERSION | |
| | | | |
| | | Comment: INSPECT POWDER COAT | <u>PC7/7/10</u> (0) |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: 12 Date: 01/07/23
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Thursday, 6/21/2007 2:28:54 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STRUT

Job Number: 33050

Part Number: D2565107

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST205

ST205

P-2/7/16 (10)

8.0 QC21

FINAL INSPECTION/W/O RELEASE



07.07.16 HJ

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



A 8/8/16

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

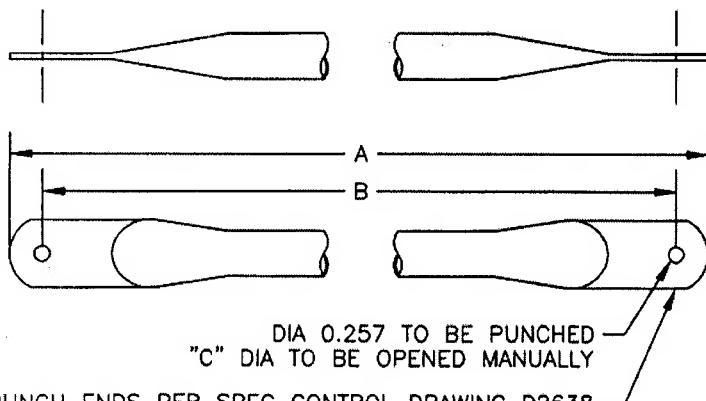
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|----------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

DART

| | | | | |
|----------|----------|---|--------------|--|
| DESIGN | DRAWN BY | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | | |
| CHECKED | APPROVED | DRAWING NO. | REV. E | |
| | | D2565 | SHEET 1 OF 1 | |
| DATE | | TITLE | SCALE | |
| 04.05.05 | | .STRUT | 1:3 | |
| A | 96.05.03 | NEW ISSUE | | |
| B | 97.03.15 | CORRECT D2565-111 DIM. A | | |
| C | 98.10.05 | UPDATED MATERIAL NOTE (TSR A603) | | |
| D | 02.06.05 | ADD -3XX PARTS; ADD FINISH | | |
| E | 04.05.05 | ADD D2565-401-411; RMV ANGLE D | | |

RELEASED
04.05.05

| PART # | A | B | DIA C |
|-----------|-------|-------|-------|
| D2565-101 | 20.52 | 19.72 | 0.316 |
| D2565-103 | 18.21 | 17.41 | 0.316 |
| D2565-105 | 20.19 | 19.39 | 0.316 |
| D2565-107 | 13.43 | 12.63 | — |
| D2565-109 | 12.31 | 11.51 | — |
| D2565-111 | 13.65 | 12.85 | — |
| | | | |
| D2565-201 | 22.79 | 22.00 | 0.316 |
| D2565-203 | 20.75 | 19.95 | 0.316 |
| D2565-205 | 21.22 | 20.42 | 0.316 |
| D2565-207 | 16.07 | 15.27 | — |
| D2565-209 | 15.16 | 14.36 | — |
| D2565-211 | 14.14 | 13.34 | — |
| | | | |
| D2565-301 | 27.03 | 26.23 | 0.316 |
| D2565-303 | 25.34 | 24.54 | 0.316 |
| D2565-305 | 23.73 | 22.93 | 0.316 |
| D2565-307 | 20.86 | 20.06 | — |
| D2565-309 | 20.17 | 19.37 | — |
| D2565-311 | 16.30 | 15.50 | — |
| | | | |
| D2565-401 | 18.29 | 17.49 | 0.316 |
| D2565-403 | 15.64 | 14.84 | 0.316 |
| D2565-405 | 19.45 | 18.65 | 0.316 |
| D2565-407 | 10.79 | 9.99 | — |
| D2565-409 | 9.34 | 8.54 | — |
| D2565-411 | 13.81 | 13.01 | — |

GENERAL NOTES

- 1) MATERIAL: AISI 304/316/318 SS 0.750 OD X 0.049 WALL
(REF. DART SPEC. M304TR0.750W0.049)
ENSURE SEAMLESS TUBE IS USED
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3 WITHOUT NOTICE
- 3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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NO. 33050

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